

Method of drilling a hole for printed wiring board.

Patent Number: ☐ EP0629109, B1
Publication date: 1994-12-14
Inventor(s): EJIRI MITSUO C O MITSUBISHI GA (JP); KINBARA HIDENORI C O MITSUBISHI (JP)
Applicant(s): MITSUBISHI GAS CHEMICAL CO (JP)
Requested Patent: ☐ JP6344297
Application Number: EP19940303982 19940603
Priority Number(s): JP19930135817 19930607
IPC Classification: H05K3/00; B23Q11/10
EC Classification: B23Q11/10, H05K3/00K4D
Equivalents: DE69404903D, DE69404903T, JP2828129B2, ☐ US5480269
Cited patent(s): EP0470757; EP0264816

Abstract

A method of drilling a through-hole for inter-surface conduction in a laminate for a printed wiring board, the laminate comprising a metal foil attached to an insulating material, with a water-soluble lubricant sheet on one surface or on front and reverse sides of the laminate, the method comprising drilling the through-holes in the presence of a water-soluble lubricant sheet which is 0.02 to 3 mm thick and is formed from a mixture of 20 to 90 % by weight of a polyether ester with 10 to 80 % by weight of a water-soluble lubricant.

Data supplied from the esp@cenet database - I2



⑫

EUROPEAN PATENT APPLICATION

⑳ Application number : **94305831.3**

⑤① Int. Cl.⁶ : **H05K 3/00, B23Q 11/10**

㉔ Date of filing : **05.08.94**

③① Priority : **05.08.93 JP 194725/93**

④③ Date of publication of application :
08.03.95 Bulletin 95/10

⑧④ Designated Contracting States :
DE FR GB NL

⑦① Applicant : **DAI-ICHI KOGYO SEIYAKU Co., Ltd.**
55 Higashi-Kubocho,
Nishi-Hichijyo,
Shimogyo-ku
Kyoto-shi, Kyoto 600 (JP)

⑦② Inventor : **Nakano, Takuji**
20-8, Nomura 5-chome
Kusatsu-shi, Shiga 525 (JP)
Inventor : **Fujita, Takeshi**
114-9, Oneo,
Hirono-cho
Uji-shi, Kyoto 611 (JP)
Inventor : **Matsuo, Katsuaki**
29-1, Mibugawa,
Chudoji, Shimogyo-ku
Kyoto-shi, Kyoto 600 (JP)
Inventor : **Isoda, Chuza**
64-9, Shinmei Miyakita
Uji-shi, Kyoto 611 (JP)

⑦④ Representative : **Marlow, Nicholas Simon**
Reddie & Grose
16, Theobalds Road
London WC1X 8PL (GB)

⑤④ Method for drilling a through hole in a laminar substrate and sheet used therein.

⑤⑦ A high molecular weight sheet comprising a composite whose principal component is a special water soluble high molecular weight compound, or a multilayer sheet wherein a water soluble high molecular weight layer is piled on sheet material is prepared. Then, said sheet is layered on entry side of a laminated substrate comprising insulating material and metallic foil. In this state, through holes are formed in the laminated substrate through said sheet. When forming through holes, said water soluble high molecular weight compound serves as lubricant so as to extend drill life. In addition, it is possible to drill a lot of substrates, which are layered, at one time, resulting in the improvement of production efficiency.

EP 0 642 297 A1

FIELD OF THE INVENTION

The present invention relates to a method for drilling thru-holes in a lamination substrate such as a multilayer printed circuit board panel, and a sheet used therein.

BACKGROUND OF THE INVENTION

When forming thru-holes in an electronic lamination substrate such as a multilayer printed circuit board panel, metallic foil is usually placed on the above circuit board panel (sometimes referred to as the panel hereinafter) and then thru-holes are formed with a gimlet, a drill, a puncher or the like. There are problems that resultant debris sticks to the panel surface, the thru-hole walls or the edges surrounding the thru-holes during the method of forming thru-holes. Furthermore, there is another problem that the thru-hole wall forms into a rough surface. Therefore, such debris must be forcefully removed by installing a suction device additionally, or debris stuck to neighboring portion of formed thru-holes must be removed by grinding cut surface in conventional methods. However, it is not preferable to add these processes like sucking debris or grinding, which make the working process complicated.

To simplify such a process, there are methods that a sheet impregnated with a water soluble lubricant is placed on one side or both sides of the above lamination substrate, in which metallic foil is layered on an insulating material, and then thru-holes are drilled through this sheet by a drill or the like, in the lamination substrate (United States Patent No. 4,781,495 and United States Patent No. 4,929,370). That is, the mixture, solid water soluble lubricant, comprising glycols such as diethylene glycol or dipropylene glycol, ester synthetic wax such as fatty acid, and a non-ionic surfactant is impregnated into a sheet such as paper, which is employed for drilling in the above method. Further, besides this method, there are methods of drilling thru-holes in a lamination substrate through a sheet wherein a high molecular layer is formed with water soluble high molecular of polyethylene glycol or polypropylene glycol solely, or water soluble high molecular mixture thereof, or fatty acid ester thereof, or the like (Tokkaihei 4-92488, Tokkaihei 4-92489, Tokkaihei 4-92490, Tokkaihei 4-92491, Tokkaihei 4-92492, Tokkaihei 4-92493, and Tokkaihei 4-92494).

However, the above methods have various defects. For example, when forming thru-holes, heat removal effect on a drill bit is not sufficient, stickiness occurs, lubricating effect cannot be obtained because water soluble high molecular is too hard to melt, or water soluble high molecular cannot be easily formed into a sheet due to inferior film formability which stems from poor thermoplasticity.

Furthermore, when using metallic foil on which water soluble compound layer is formed or a wear plate of metallic foil wherein water soluble compound layer is directly formed therein to form thru-holes by a drill or a gimlet, the above water soluble compound may sometimes stick to the drill or the gimlet. For example, when forming thru-holes with a drill or a gimlet at a high speed rotation such as 50,000 to 100,000rpm, since debris of the above water soluble compound sticks to the blade of the drill or the gimlet, the rotation balance may be disturbed. Therefore, the bit of the drill or the gimlet passes through the lamination substrate slantwise, not vertically. If a few lamination substrates are layered in such a forming process, the tip of the drill or gimlet passes through it slantwise, resulting in accuracy deterioration because the discrepancy is caused between the hole positions of the entry sheet and the exit sheet. For example, if the discrepancy between the entry sheet and the exit sheet reach 200 μ m, later processing becomes impossible.

Especially, the diameter of thru-holes has recently become smaller such as 0.5mm, 0.3mm, 0.25mm and 0.20mm due to the rise of packing density. For this reason, it is required to control effectively frictional heat caused in cutting with the drill and also heighten accuracy of the positioning of thru-holes.

It is desired to provide a method of drilling thru-holes in a lamination substrate, superior in heat removal effect, lubricating effect and preventive effect of smear in forming thru-holes, resulting in easy process of forming thru-holes with a high accuracy, and a sheet for drilling process employed therein.

According to a first aspect of the invention there is provided a method for drilling a through hole in a laminar substrate of an insulating material and a metal foil, the method comprising:

placing either:

(Y) a high molecular weight sheet comprising a water soluble high molecular weight compound, a principal component of which is P or Q; or

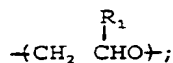
(Z) a multilayer sheet comprising a plurality of water soluble high molecular weight layers on a sheet material, a principal component of which is P or Q

on the entry surface of the substrate; and

forming a through hole in the substrate through the sheet (Y) or (Z), wherein:

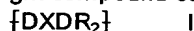
P is a water soluble high molecular weight compound comprising an organic residue having two active hydrogen groups:

{CH₂ CH₂O} in an amount of at least 70% by weight; and



and

Q is a water soluble high molecular weight compound comprising the repeating unit I:



wherein:

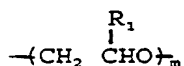
R₁ is a hydrocarbon group;

R₂ is a polycarboxylate residue or a diisocyanate residue;

D comprises:

{CH₂ CH₂O}_n wherein n is a positive number, {CH₂ CH₂O} comprising at least 70% by weight of D;

and



wherein m is 0 or a positive number; and

X is an organic residue with two active hydrogen groups.

In a second aspect, the invention provides a single layer sheet for use in drilling comprising a water soluble high molecular weight compound the principal component of which is P or Q.

In a third aspect, the invention provides a multilayer sheet for drilling obtained by layering a water soluble high molecular weight compound layer the principal component of which is P or Q.

Namely, inventors of the present invention have conducted a series of researches on a method of forming fine thru-holes having a clean cut wall, which prevents heat generation, is superior in lubricating effect, and also prevents debris from spreading. As a result, they came up with an idea of employing a sheet (sheet Y) comprising a water soluble high molecular weight single-layer sheet wherein the principal component is a special water soluble high molecular weight compound superior in lubricating effect due to low melting point, or a sheet (sheet Z) wherein the above water soluble high molecular weight sheet is layered on sheet material. When forming thru-holes through this sheet layered on the substrate, a water soluble high molecular weight layer is easily melted with frictional heat caused by rotation of a drill and the like, so as to incorporate debris, resulting in prevention of wall surface roughness and breaking or damage of a drill bit with the heat rise by frictional heat because the above melted water soluble high molecular weight compound works as lubricant. That is, since melting point of the above specific water soluble high molecular weight compound is low, the above water soluble high molecular weight compound melts immediately by heat generated in drilling thru-holes, whereby heat removal effect and lubricating effect show so as to prevent surface roughness. Furthermore, the process after forming thru-holes can be simplified because grinding surface is unnecessary. Especially, the effect of the drilling method according to this invention is remarkable when forming very small thru-holes like not more than 0.5mm in diameter. Generally, when diameter of thru-holes is small, diameter of a drill bit or gimlet becomes small, which easily damages the bit with frictional heat occurred in forming thru-holes in the laminated substrate. As a result, only one or two pieces of laminated substrate can be layered. However, according to this invention, it is possible to layer three or four pieces of laminated substrate, which enables to improve production efficiency.

Among all, in three-layer structure, one embodiment of the above sheet Z, multilayer structure, it is avoidable for debris to stick to the blade of a drill or a gimlet because the above water soluble high molecular weight layer is sandwiched between upper and lower sheet material. Namely, since sheet material sandwiching the water soluble high molecular weight sheet prevents sticking, resulting in substantially no adhesion occurred. Therefore, if a drill and the like rotates at high speed, its bit does not break and contacts an object to be drilled, resulting in no discrepancy among hole positions of each substrate.

Furthermore, according to this invention, there is a characteristic of very low occurrence of haloing in coppering after drilling because cut surface roughness is very low. When haloing occurs in an inner copper layer of multilayer panel, copper rusts on the portion where haloing is caused as time passes, or sometimes copper circuit is disconnected. Therefore, it is required to control the occurrence of haloing as much as possible. The above haloing is caused because galvanizing liquid permeated into the inner copper layer is difficult to remove

in a rinsing process after galvanizing, resulting in copper rust due to this galvanizing liquid. In addition, there is a method of preventing oxidation of galvanizing liquid with reducing agent before galvanizing. In this case, a process become complicated because reducing process is added. In the present invention, it is effective to prevent haloing without any additional process.

5 The present invention is now described in further detail.

The laminated substrate in this invention comprises various printed circuit panel substrate wherein metallic foil and insulating material are layered and laminated. For example, there are metallic-foil layered laminated substrate, multilayer laminated substrate having printed circuit panel therein, metallic-foil layered laminated substrate having printed circuit panel therein, metallic foil layered plastic film and the like.

10 As substrate forming the above laminated substrate, for example, there are, glass fabric impregnated with epoxy resin (both sides coated with copper foil), glass fabric impregnated with epoxy resin (single side coated with copper foil), glass fabric impregnated with polyimide resin (both sides coated with copper foil), glass fabric impregnated with polyimide (single side coated with copper foil), glass fabric impregnated with fluororesin (both sides coated with copper foil), glass fabric impregnated with heat curing polyphenylene oxide (PPO) resin (both sides coated with copper foil), glass nonwoven fabric cloth impregnated with epoxy resin (both sides coated with copper), glass nonwoven fabric cloth impregnated with epoxy resin (single side coated with copper) and the like. The substrate can be formed by layering one or more of the above base material. Among all, a multilayer substrate can be obtained by etching a desired circuit on each substrate, and heat compressing each of them with employing prepreg to form.

20 A special sheet for drilling is employed in a method for drilling thru-holes in a laminated substrate of the present invention.

The above special sheets for drilling are roughly separated into two kinds of sheets. One is the single-layer structure of water soluble high molecular weight sheet formed by high molecular weight layer whose principal component is a special high molecular weight compound (sheet Y). Another one is the sheet of multilayer structure wherein water soluble high molecular weight layer is layered on the base material (sheet Z).

First of all, sheet Y of the above single-layer is described.

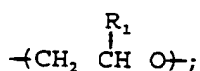
The water soluble high molecular weight sheet of the above sheet Y is formed by high molecular weight layer wherein a special water soluble high molecular weight compound is principal component. In addition, "~ is a principal component" contains the case of "~ is the only one component".

30 The above water soluble high molecular weight compound comprises at least one selected from the group consisting of the following component P and component Q:

P is a water soluble high molecular weight compound comprising an organic residue having two active hydrogen groups;

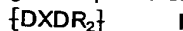
$\{CH_2 CH_2 O\}$ in an amount of at least 70% by weight; and

35



40 and

Q is a water soluble high molecular weight compound comprising the repeating unit I



As components of the above P, R_1 is favorably a methyl group, an ethyl group, or a phenyl group. Besides, weight average molecular weight is preferably set up not less than 1,000, most preferably 6,000 to 1,000,000. That is, when weight average molecular weight of P component is less than 1,000, the water soluble high molecular weight compound is liquefied at a normal temperature, which does not meet with the object of the present invention.

The above P can be obtained by addition polymerizing alkylene oxide whose principal component is ethylene oxide, into an organic compound having two hydrogen groups.

50 As the above organic compound having two active hydrogen groups, there are alicyclic diol such as ethylene glycol, diethylene glycol, propylene glycol, dipropylene glycol, 1,4-butanediol, 1,6-hexanediol, neopentylglycol, bisphenol A, polytetramethylene glycol, cyclohexane-1,4-dimethanol, and amines such as butylamine, octylamine, laurylamine, cyclohexylamine, aniline. These are employed solely or in combination.

As alkylene oxide, mainly made of ethylene oxide, containing for addition polymerization with the above organic compound, there are ethylene oxide solely, the mixture of ethylene oxide as a main component and propylene oxide, butylene oxide, styrene oxide, α -olefin epoxide, glycidyl ether or the like. In addition, the content of the above ethylene oxide is set up not less than 70% by weight (abbreviated as % hereinafter).

The above component P can be obtained by employing each ingredient of the above, and reacting them

with caustic alkali such as sodium hydroxide or potassium hydroxide as a catalyzer at a temperature between about 90° and 200 °C for 2 to 30 hours so as to addition polymerize at block or random alkylene oxide containing ethylene oxide to the organic compound having two active hydrogen groups. Besides, there are another method that alkali metal catalyzer is dispersed into hydrocarbon solvent and alkylene oxide is added to addition polymerize with an organic compound having two active hydrogen groups.

Now, component Q is described. The above Q is a water soluble high molecular weight compound composed of a repetitive unit represented as the above formula (I). R₂ of the formula (I) is preferably a methyl group, an ethyl group or a phenyl group. Further, the weight average molecular weight is set up preferably not less than 10,000, more preferably 30,000 to 200,000, most preferably 80,000 to 160,000. The water soluble high molecular weight compound composed of the repetitive unit represented as the above general formula (I) can be obtained by employing the following two components (A) and (B).

(A) is a polyalkylene compound prepared by addition polymerizing alkylene oxide, whose principal component is ethylene oxide, with an organic compound having two active hydrogen groups;

(B) is a polycarboxylate compound or a diisocyanate compound.

As the organic compound having two active hydrogen groups of the above (A), there are the same as mentioned in the above component P.

As alkylene oxide, whose principal component is ethylene oxide for addition copolymerization with the above organic compound, there are the same as mentioned in the above P. The content of the above ethylene oxide is set up not less than 70% same as the above component P.

The above (A) can be obtained by employing each ingredient of the above, and reacting them with caustic alkali such as sodium hydroxide or potassium hydroxide as a catalyzer at a temperature between about 90° and 200 °C for 2 to 30 hours so as to addition polymerize at block or random alkylene oxide containing ethylene oxide to the organic compound having two active hydrogen groups. Besides, there are another method that alkali metal catalyzer is dispersed into hydrocarbon solvent and alkylene oxide is added to addition polymerize with an organic compound having two active hydrogen groups.

The weight average molecular weight of (A), polyoxy alkylene polyol, obtained by employing each ingredient of the above is preferably not less than 1,000, most preferably from 5,000 to 30,000. That is, if the weight average molecular weight is less than 1,000, the mixing ratio of the above corresponding (B), the connecting agent of dicarboxylate compound or diisocyanate compound increases so that the tendency of deterioration of solubility in water can be seen. On the other hand, if the weight average molecular weight is between 5,000 and 30,000, the melting point of the water soluble high molecular weight compound obtained by reacting with the connecting agent of (B) becomes moderately high, and also good film formability.

As polycarboxylate compound of (B), which reacts with the above (A), there are polycarboxylic acid, polycarboxylate anhydride, lower alkyl ester of polycarboxylic acid. As the above polycarboxylic acid, there are dicarboxylic acid such as phthalic acid, isophthalic acid, terephthalic acid, malonic acid, succinic acid, sebacic acid, maleic acid, fumaric acid, adipic acid, itaconic acid and the like, and tetracarboxylic acid such as pyromellitic acid. As the above polycarboxylate anhydride, there is each anhydride of the above various polycarboxylic acids. Finally, as the lower alkyl ester of the above polycarboxylic acid, there are methyl ester, dimethyl ester and the like of each polycarboxylic acid of the above. These are employed solely or in combination.

As diisocyanate compound of the above (B), specifically, there are tolylenediisocyanate, diphenylmethane diisocyanate, hexamethylene diisocyanate, isophorone diisocyanate, xylene diisocyanate, 4,4'-methylene-bis(cyclohexyl isocyanate) and the like. There are employed solely or in combination.

The water soluble high molecular weight compound [component Q] composed of a repetitive unit represented as general formula (I) can be obtained by reacting the above (A) and (B) as follows. The first case that (B) is polycarboxylate compound is described. That is, the above (A) is prepared, and the above (B) is added therein. The mixture of (A) and (B) is heated. Then, dehydration or dealcoholization is conducted under heating condition at 80° to 250°C and reduced pressure into 0.1 to 2.7 x 10³ Pa, resulting in the water soluble high molecular weight compound. The time for such a reaction is usually 30 minutes to 10 hours.

The mixing ratio (A/B) of both (A) and (B) to be reacted is preferably set within the scope of A/B = 1/0.90 to 1/3.50 at equivalent ratio, more preferably A/B=1/0.95 to 1/3.50.

Next, another case that the above (B) is polyisocyanate compound is described. The reaction to be urethanated in diisocyanate compound is conducted, for example, by mixing polyalkylene oxide and diisocyanate compound within the scope of 0.5 to 1.5 at equivalent ratio of NCO/OH so as to be reacted at a temperature of 80° to 150°C for 1 to 5 hours.

The weight average molecular weight of thus obtained water soluble high molecular weight compound Q is preferably set at not less than 10,000, more preferably 30,000 to 200,000, most preferably 80,000 to 160,000, as mentioned above. If the weight average molecular weight is less than 10,000, mechanical strength is low and there is a tendency that secondary workability is inferior. On the other hand, if the weight average molec-

ular weight is over 200,000, flowing characteristic in melt condition is deteriorated and melt fracture phenomenon is caused, resulting in impossibility of extrusion moulding.

Besides, it is possible to mix appropriately polyethylene glycol, water soluble lubricant such as a non-ionic surfactant, water soluble anti-rust agent and the like into the above P and Q components to improve lubrication according to the case.

The sheet Y employed for drilling in this invention can be manufactured, for example, by a following method. That is, the sheet Y can be manufactured in a normal method such as solution casting method, fusion intrusion with T-die or inflation, or calendering method by employing the above specific water soluble high molecular weight compound.

As the thickness of the above sheet Y, 50 to 500 μm is preferable.

Now, multilayer structure sheet (sheet Z) is described.

The multilayer structure sheet for forming the above sheet Z comprises sheet material and water soluble high molecular weight layer whose principal component is at least one component selected from the group composed of the above P and Q formed on the above sheet material surface. In addition, such expression as "is principal component" contains a case that "is the only one component".

As the above components P and Q there are the same water soluble high molecular weight compound as employed in the above single-layer structure sheet Y.

The above sheet material is not critical, however, metallic foil is preferable. Among all, there are foils of aluminium, zinc, iron and the like. The thickness of the sheet material is set between 50 to 500 μm .

As this sheet Z, multilayer structure, there are, for example, the following structures.

① A sheet wherein water soluble high molecular weight layer is formed on one side or both sides of the sheet material.

② A sheet of three-layer structure wherein water soluble high molecular weight layer is sandwiched between two sheets of the sheet material.

The above ① is manufactured, for example, by the following method. That is, the water soluble high molecular weight film is manufactured by solution casting method, fusion extrusion like T-die or inflation, or calendering method with a forming material wherein the above specific water soluble high molecular weight compound is a principal component. Then, this water soluble high molecular weight film and sheet material are layered and laminated so that ① is manufactured. Or, the specific water soluble high molecular weight compound is dissolved into water or organic solvent, and the mixture is coated on the above sheet material surface thinly, and finally the above organic solvent is completely removed at a temperature 40° to 50 °C so that ① is manufactured. In this case, the special high molecular weight layer can be formed by coating the one side or both sides of the sheet material thinly therewith.

The three-layer sheet of the above ② is manufactured, for example, by the following method. That is, the water soluble high molecular weight sheet is manufactured in the same manner as the above ①. Then, three-layer structure sheet shown in Fig. 1 can be obtained by placing sheet material so as to sandwich the above water soluble high molecular weight sheet and adhering them to be laminated. In the figure, 1 is water soluble high molecular weight layer and 2 is metallic foil.

Alternatively, the above specific water soluble high molecular weight compound [component P and component Q] is dissolved into water or organic solvent. This solution is coated on the above metallic foil thinly. Then the above organic solvent is completely removed at a temperature 40 ° to 50 °C to manufacture a two-layered product of the water soluble high molecular weight layer and the sheet material. Subsequently, the sheet material is adhered to the water soluble high molecular weight layer side of such a two-layered product to be laminated, so that the three-layer structure sheet can be obtained.

In addition, as the sheet material of two layers in the above three-layer structure ②, either the same material or different material may be used.

The thickness of the above sheet Z is preferably set within the range of 50 to 500 μm in both the above ① and ②. The thickness of the entire sheet of two-layer structure is preferably 100 to 1,000 μm , while that of three-layer structure is preferably 150 to 1,500 μm .

Drilling through a laminated substrate (i.e., a printed circuit board panel) in this invention is conducted, for example, in the following method. First of all, a normal laminated substrate as an object to be drilled is prepared. On the other hand, the above sheet 4 for drilling is prepared. As shown in Fig. 2, the sheet 4 is layered on the entry substrate, from which the drill or the gimlet starts to pass through (in the direction indicated by an arrow), of the above laminated substrate 3 so that thru-holes are formed in a desired diameter on a desired position of the laminated substrate 3 through the sheet 4. In this way, drilling is conducted.

The sheet 4 is preferably positioned on both sides of the laminated substrate 3, however, when the sheet is placed only on one side of the laminated substrate 4, it must be positioned on the entry side of drilling. In addition, when the sheet 4 comprises a two-layer structure of the sheet material and a water soluble high mo-

lecular weight layer, the water soluble high molecular weight layer surface is preferably positioned so as to face the laminated substrate 3 each other.

EFFECTS OF THE INVENTION

As aforementioned, when forming thru-holes in the laminated substrate, a single-layer sheet (sheet Y) mainly made of the special water soluble high molecular weight compound [component P component Q], or a multilayer sheet (sheet Z), wherein special water soluble high molecular weight layer(s) is/are layered on the sheet material surface, is piled on the above laminated substrate, so that drilling is performed. For this reason, when drilling, the above water soluble high molecular weight layer(s) melt(s) and incorporate(s) debris so as to prevent not only cut surface roughness, but also the rise of temperature caused by frictional heat and also the drill bit fracture, because melted water soluble high molecular weight compound serves as lubricant. In addition, it is not necessary to grind the cut surface after drilling, resulting in simplification of the process. Especially, the drilling method of this invention is suitable for drilling small thru-holes not more than 0.5mm in diameter. Therefore, in drilling a substrate, usually only 1 or 2 pieces can be layered, however, according to this invention, 3 or 4 pieces can be layered for drilling, which can improve a production efficiency.

Furthermore, since the above water soluble high molecular weight layer is sandwiched between the upper and lower substrates in one embodiment employing the multilayer structure sheet, sheet Z, in the present invention, the debris are not easily adhered to the blade of the drill or the gimlet. Namely, since adhesion is prevented by the sheet material sandwiching the water soluble high molecular weight layer, substantially no debris sticks to the blade. Therefore, even if a drill and the like rotates at a high speed, the drill tip will not break and contact the object for drilling thru-holes. As a result, when drilling thru-holes on multilayer substrates, there causes no discrepancies among all substrates, which enables forming thru-holes at a high accuracy in positioning because the drill bit can contact the object to be drilled without the drill bit fracture at the high speed rotation.

Furthermore, according to drilling method of the present invention, since the degree of the cut surface roughness is low, occurrence of haloing can be greatly restrained in coppering after drilling. When haloing occurs in an inner copper layer in multilayer substrates, copper rusts as time goes, sometimes copper circuit is disconnected. Therefore, it is required to prevent haloing. The above haloing is caused because galvanizing liquid permeated into the copper inner layer is difficult to remove in a rinsing process after galvanizing, resulting in copper rust due to this galvanizing liquid. In addition, there is a method of preventing oxidation of galvanizing liquid with reducing agent before galvanizing. However, in this case, a process become complicated because reducing process is incorporated therein additionally. In the present invention, it is effective to prevent haloing without any additional process.

The following examples and comparative examples are further illustrative of the present invention.

(i) First of all, the sheet Y, single-layer structure, is described.

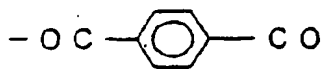
BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a cross-sectional view illustrating one example of a sheet for drilling in the present invention and Fig. 2 is a schematic view illustrating the method of drilling in the present invention.

EXAMPLE 1

2.2 parts of dimethyl terephthalate were added in 100 parts by weight (abbreviated as parts hereinafter) of polyethylene glycol obtained by adding ethylene oxide into ethylene glycol (weight average molecular weight: 10,000). A normal transesterification was conducted to obtain water soluble high molecular compound whose weight average molecular weight is 130,000 and water solution viscosity is 250cps (30°C, B-type viscometer). [In the repetitive unit represented as the above general formula (I), D, X and R₂ are as follows.]

D : {CH₂ CH₂ O}
X : - OCH₂ CH₂ O-
R₂ :



This water soluble high molecular compound was used to be extruded into a sheet in 100 μm thick of water

soluble high molecular sheet by uniaxial extruder under the condition at a T-die temperature of 90 °C.

EXAMPLE 2

The water soluble high molecular compound (weight average molecular weight: 100,000) at 10% of water solution viscosity and 600cps (30°C, B type viscometer) was obtained by condensation polymerizing 840 parts of polyethylene glycol (molecular weight: 8,400) with 23.2 parts of dimethyl sebacate. [In the repetitive unit represented as the above general formula (I), D, X and R₂ are as follows.]

D : {CH₂ CH₂ O}

X : -OCH₂ CH₂ O-

R₂: -OC (CH₂)₈ CO-

By employing this water soluble high molecular compound, water soluble high molecular film in 200 μm thick was manufactured in the same manner as EXAMPLE 1.

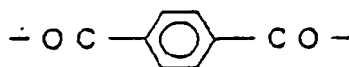
EXAMPLE 3

180 parts of ethylene oxide was added in 20 parts of polypropylene glycol (molecular weight: 2,000) for reaction so that polyalkylene glycol (weight average molecular weight: 20,000) was obtained. Then, 200 parts of this polyalkylene glycol and 1.94 parts of dimethyl terephthalate were condensation polymerized so that water soluble high molecular compound at weight average molecular weight of 140,000 and 10% water solution viscosity of 260cps (30°C, B type viscometer) was obtained. [In the repetitive unit represented as the above general formula (I), D, X and R₂ are as follows.]

D : {CH₂ CH₂ O}

X : -OCH₂ CHCH₃ O-

R₂ :



By employing this water soluble high molecular compound, water soluble high molecular film in 200 μm thick was manufactured in the same manner as EXAMPLE 1.

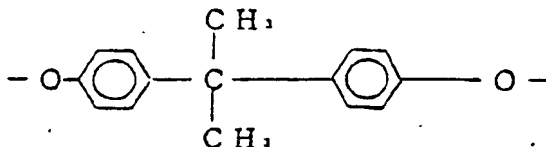
EXAMPLE 4

0.84 parts of hexamethylene diisocyanate and small amount of dibutyltin dilaurate are added into 100 parts of polyalkylene oxide compound (weight average molecular weight 20,000) obtained by block-addition polymerizing alkylene oxide comprising 85% ethylene oxide and 15% propylene oxide into bisphenol A, and then urethanated at 100 °C, so as to prepare water soluble high molecular compound of weight average molecular weight 2,500,000, 2% water solution viscosity 2,000 cps (30°C, B type viscometer), and melt viscosity 58 °C. [In the repetitive unit represented as the above general formula (I), D, X and R₂ are as follows.] In addition, NCO/OH equivalent ratio is 1 in the above urethanation.

D : a unit composed of a repetition of {CH₂ CH₂ O} and



X :



$R_2 : -NHCO(CH_2)_6NHCO-$

By employing this water soluble high molecular compound, water soluble high molecular film in 100 μ m thick was manufactured in the same manner as EXAMPLE 1.

5 EXAMPLE 5

The mixture composed of 60 parts of polyethylene glycol (molecular weight 1,000,000) and 40 parts of polyethylene glycol distearate (molecular weight: 4,000) are prepared. A water soluble high molecular sheet in 100 μ m thick was manufactured from the mixture in the same method of EXAMPLE 1.

10

EXAMPLE 6

Water soluble high molecular compound (weight average molecular weight 20,000) was prepared by block-addition polymerizing alkylene oxide comprising 85% ethylene oxide and 15% propylene oxide into bisphenol A. This water soluble high molecular compound showed 10% water solution viscosity 9.5cps (30 °C, B type viscometer) and melt viscosity 60°C.

15

By employing this water soluble high molecular compound, water soluble high molecular film in 100 μ m thick was manufactured at a T-die temperature 90°C with uniaxial extruder.

(ii) The two-layer structure sheet as one of sheet Z, multilayer structure.

20

EXAMPLE 7

Solution at 30% condensation was prepared by dissolving the water soluble high molecular compound (weight average molecular weight 130,000) obtained in EXAMPLE 1 into the mixed solvent of water and methanol (mixing ratio=1:1 by weight). This solution was coated in 100 μ m thick on aluminium foil surface in 100 μ m thick with a doctor blade (doctor blade DP-150, manufactured by Tsugawaseiki-seisakusho). Aluminium foil with water soluble high molecular film thereon was produced in this way.

25

EXAMPLE 8

Solution at 30% condensation was prepared by dissolving 30 parts of the water soluble high molecular compound (weight average molecular weight 100,000) obtained in EXAMPLE 2 into 70 parts of water. This solution was coated on aluminium foil surface in 100 μ m thick with a doctor blade (doctor blade DP-150, manufactured by Tsugawaseiki-seisakusho). Aluminium foil with water soluble high molecular film thereon was produced in this way.

30

35

EXAMPLE 9

Water soluble high molecular sheet produced in the above EXAMPLE 6 was prepared. In the meantime, aluminium foil in 150 μ m thick prepared. Aluminium foil is adhered to the above water soluble high molecular sheet by adhesion [diabond No.160, manufactured by Nogawa Chemical Co., Ltd.] to be integrated, and a sheet for drilling was obtained.

40

(iii) The three-layer structure in other structures of multilayer structure, sheet Z.

45

EXAMPLE 10

A water soluble high molecular sheet (100 μ m thickness) of the above EXAMPLE 1 was prepared. Then, two pieces of aluminium foil in 150 μ m thick were prepared. Each aluminium foil was adhered to both sides of the water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

50

EXAMPLE 11

60 parts of polyethylene glycol (molecular weight 1,000,000) and 40 parts of polyethylene glycol distearate (molecular weight 4,000) were dissolved into water so as to prepare solution. The solution was coated in 100 μ m thick on the aluminium foil surface with a doctor blade (doctor blade device DP-150, manufactured by Tsugawaseiki-seisakusho) so as to form a water soluble high molecular layer. Furthermore, aluminium foil in 100 μ m thick was adhered to the above water soluble molecular layer side with adhesive [diabond No. 160, man-

55

ufactured by Nogawa Chemical Co., Ltd.] so that a sheet for drilling was obtained.

EXAMPLE 12

A water soluble high molecular sheet (200 μm thickness) on the above EXAMPLE 2 was prepared. Then, two pieces of aluminium foil in 150 μm thick were prepared. Each aluminium was adhered to both sides of the above water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

EXAMPLE 13

A water soluble high molecular sheet (200 μm thick) of the above EXAMPLE 3 was prepared. Then, two pieces of aluminium foil in 200 μm thick were prepared. Each aluminium was adhered to both sides of the above water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

EXAMPLE 14

A water soluble high molecular compound (weight average molecular weight 20,000) was prepared by block-addition polymerizing alkylene oxide comprising 85% ethylene oxide and 15% propylene oxide into bisphenol A. water solution viscosity is 9.5cps (30°C, B type viscometer) and melt viscosity is 60 °C in this water soluble high molecular compound.

A water soluble high molecular sheet in 50 μm thick was obtained by extruding the above water soluble high molecular compound with a uniaxial extruder at a T-die temperature 90°C into a sheet. Then, two pieces of aluminium foil in 150 μm thick were prepared. Each aluminium was adhered to both sides of the above water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

EXAMPLE 15

A water soluble high molecular sheet (100 μm thick) of the above EXAMPLE 4 was prepared. Then, two pieces of aluminium foil in 150 μm thick were prepared. Each aluminium was adhered to both sides of the above water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

COMPARATIVE EXAMPLE 1

A water soluble sheet (100 μm thick) formed with 50 parts of polyethylene oxide (weight average molecular weight 1,100,000) and 50 parts of polyoxyethylene sorbitan monostearate was prepared.

Then, two pieces of aluminium foil in 150 μm thick were prepared. Each aluminium was adhered to both sides of the above water soluble high molecular sheet with adhesive [diabond No. 160, manufactured by Nogawa Chemical Co., Ltd.] to be laminated so that a sheet for drilling was obtained.

COMPARATIVE EXAMPLE 2

Aluminium foil in 100 μm thick was prepared.

COMPARATIVE EXAMPLE 3

250 parts of dipropylene glycol, 670 parts of non-ionic surfactant [trihydroxystearin and a water soluble wax [polyethylene glycol (PEG-6000) : molecular weight 8,500] and 80 parts of fatty acid ester (glycerine stearic acid ester) were mixed to form material for a lubricant sheet. The lubricant sheet was coated on one side of water soluble paper by a roller and dried so as to manufacture a sheet wherein a lubricant film layer in 4.5mil was formed.

On the other hand, six-layer glass fabric base material epoxy substrate was produced as follows. First of all, R1766T [manufactured by Matsushita Electric Works Ltd., both sides with copper foil] / R1661T [manufactured by Matsushita Electric Works Ltd., prepreg layer (0.15mm thick)] / R1766T / R1661T / R1766T were combined in this order to be laminated, heated at 120 °C under condition of 40kg/m² pressure for 10 to 15 min-

utes by a heat-pressing device, and heat formed at 170 °C for not less than 40 minutes, so that three pieces of six-layer glass fabric base material epoxy substrate were produced.

Then, three pieces of the six-layer substrate thus obtained were adhered and layered and a sheet for drilling was layered on the substrate as follows. (from the entry side) A sheet for drilling or aluminium foil / the first six-layer glass fabric base material epoxy substrate / the second six-layer glass fabric base material epoxy substrate / the third six-layer glass fabric base material epoxy substrate / paper phenol laminate.

Drilling on the above EXAMPLES and COMPARATIVE EXAMPLES was conducted under the following condition. Then, after using 4,000 hits, drilling was conducted. Each cut surface was valued by visual observation. The results are shown in Table 1 below. In addition, evaluation in Table 1 is indicated by the following four steps.

- ① : No debris could be seen.
 ○ : Substantially no debris could be seen.
 △ : A small amount of debris could be seen.
 X : A lot of debris could be seen.

[Drilling condition]

- ① Drill bit diameter: 0.30mm
 ② Drill revolution speed: 80,000rpm
 ③ Feed speed: 1.6mm/min

TABLE 1

EVALUATION AFTER DRILLING			
EXAMPLE	1st substrate	2nd substrate	3rd substrate
1	○	○	○
2	○	○	○
3	○	○	○
4	○	○	○
5	○	○	○
6	○	○	○
7	○	○	○
8	○	○	○
9	○	○	○
10	○	○	○
11	○	○	○
12	○	○	○
13	○	○	○
14	○	○	○
COMPARATIVE			
EXAMPLE			
1	X	X	X
2	△	△	X
3	X	X	X

As results from the above Table 1, no debris was identified in three substrates of all EXAMPLES, which shows that debris was acquired by the water soluble high molecular compound melted with heat in drilling. On the other hand, a lot of debris was identified in three substrates and also cut surfaces were rough in COMPARATIVE EXAMPLE 1. Furthermore, debris was identified and debris stuck to thru-holes and the neighboring portion in COMPARATIVE EXAMPLE 2.

Then, surface roughness of the inner copper layer in the multilayer lamination substrate, which was drilled, was valued by visual observation. The results will be shown in Table 2. In addition, evaluation in Table 2 is indicated by the following four steps. That is, first of all, to expose the inner copper surface of each multilayer lamination substrate for evaluation, upper layers such as epoxy resin layer and the like were grinded by a grind-

er till the copper surface was seen. When the copper surface was seen, enlarged photograph of each the portion was taken by microscope. From the photographs, centering around thru-holes, surface roughness was valued by visual observation. In addition, each inner copper of the third substrate of six-layer substrate from the entry side was exposed so that microphotographs were taken for evaluation.

- 5 ⊙ : No haloing could be seen.
 ○ : Substantially no haloing could be seen.
 Δ : A small amount of haloing could be seen.
 × : Haloing could be seen.

TABLE 2

EVALUATION OF HALOING
 3rd inner copper of 3rd lamination substrate

15	<u>EXAMPLE</u>	
	1	⊙
	2	⊙
	3	⊙
20	4	⊙
	5	⊙
	6	⊙
	7	⊙
	8	⊙
25	9	⊙
	10	⊙
	11	⊙
	12	⊙
30	13	⊙
	14	⊙
	<u>COMPARATIVE</u>	
	<u>EXAMPLE</u>	
35	1	×
	2	×
	3	×

40 From the results of Table 2, it is found out that no haloing could be seen and occurrence of haloing was prevented in EXAMPLE 1 to 14. On the other hand, haloing was obviously identified in COMPARATIVE EXAMPLES.

Then, the accuracy of positioning thru-holes was valued as follows. That is, positioning in each substrate was decided before drilling with a driller and drilling was conducted on three-layered substrates. After that, the discrepancy between center positions of the first substrate and the third substrate was measured by calipers. The results are shown in Table 3. In addition, each evaluation was indicated by the following four steps.

- 45 ⊙ : No discrepancy could be seen.
 ○ : Substantially no discrepancy could be seen.
 Δ : A little discrepancy could be seen. (about 50 to 75 μm)
 × : Discrepancy could be seen. (not less than 100 μm)

50

55

TABLE 3

ACCURACY OF POSITIONING THRU-HOLES

5

10

15

20

25

30

35

40

45

50

55

EXAMPLE

1
2
3
4
5
6
7
8
9
10
11
12
13
14

COMPARATIVE
EXAMPLE

1
2
3



From the results of Table 3, no discrepancy between the first substrate and the third substrate could be seen in all EXAMPLES. On the other hand, there was a discrepancy of 120 μm between the first one and the third one.

Claims

1. A method for drilling a through hole in a laminar substrate of an insulating material and a metal foil, the method comprising:

placing either:

(Y) a high molecular weight sheet comprising a water soluble high molecular weight compound, a principal component of which is P or Q; or

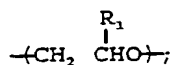
(Z) a multilayer sheet comprising a plurality of water soluble high molecular weight layers on a sheet material, a principal component of which is P or Q

on the entry surface of the substrate; and

forming a through hole in the substrate through the sheet (Y) or (Z), wherein:

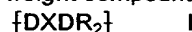
P is a water soluble high molecular weight compound comprising an organic residue having two active hydrogen groups:

$\{\text{CH}_2 \text{CH}_2\text{O}\}$ in an amount of at least 70% by weight; and



and

Q is a water soluble high molecular weight compound comprising the repeating unit I:

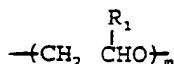


wherein:

R₁ is a hydrocarbon group;

R₂ is a polycarboxylate residue or a diisocyanate residue;
D comprises:

{CH₂ CH₂O}_n wherein n is a positive number, {CH₂ CH₂O} comprising at least 70% by weight of D; and



wherein m is 0 or a positive number; and

X is an organic residue with two active hydrogen groups.

2. A method according to claim 1 in which the multilayer sheet Z comprises a sheet material having the water soluble high molecular weight layer on one side.
3. A method according to claim 1 wherein the multilayer sheet Z is a three-layer structure comprising the water soluble high molecular weight layer and sheet material sandwiching the water soluble high molecular weight layer.
4. A method according to any preceding claim wherein the sheet material is metallic foil.
5. A method according to any preceding claim wherein the weight average molecular weight of the water soluble high molecular weight compound of component P is not less than 1,000.
6. A method according to any preceding claim wherein the weight average molecular weight of the water soluble high molecular weight compound of component Q is not less than 10,000.
7. A method according to any preceding claim wherein the water soluble high molecular weight compound of component P is a polyalkylene oxide compound obtained by addition polymerizing an alkylene oxide mainly composed of ethylene oxide into an organic compound having two active hydrogen groups.
8. A method according to any preceding claim wherein the water soluble high molecular weight compound of component Q is formed by reacting the following (A) and (B):
(A) is a polyalkylene oxide compound obtained by addition polymerizing an alkylene oxide mainly composed of ethylene oxide into an organic compound having two active hydrogen groups;
(B) is a polycarboxylate compound or a diisocyanate compound.
9. A single layer sheet for use in drilling comprising a water soluble high molecular weight compound the principal component of which is P or Q, wherein P and Q have the same meaning as in claim 1.
10. A multilayer sheet for drilling obtained by layering a water soluble high molecular weight compound layer the principal component of which is P or Q, wherein P and Q have the same meaning as in claim 1.
11. A sheet according to claim 10 wherein the water soluble high molecular weight layer is on one side of the sheet material.
12. A sheet according to claim 10 wherein the sheet is a three-layer structure comprising the water soluble high molecular weight layer and two pieces of sheet material sandwiching the water soluble high molecular weight layer.
13. A sheet according to any of claims 10 to 12 wherein the sheet material is metallic foil.
14. A sheet according to any of claims 9 to 13 wherein the weight average molecular weight of the water soluble high molecular weight compound of component P is not less than 1,000.
15. A sheet according to any of claims 9 to 14 wherein the weight average molecular weight of component Q is not less than 10,000.
16. A sheet according to any of claims 9 to 15 wherein the water soluble high molecular weight compound of

component P is formed by addition polymerizing an alkylene oxide consisting mainly of ethylene oxide into an organic compound having two active hydrogen groups.

- 5 17. A sheet according to any of claims 9 to 15 wherein the water soluble high molecular weight compound of component Q is formed by reacting (A) and (B), wherein (A) and (B) have the same meaning as in claim 8.

10

15

20

25

30

35

40

45

50

55

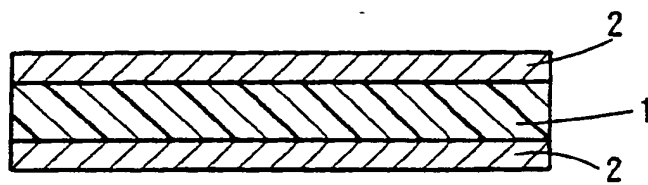


FIG. 1

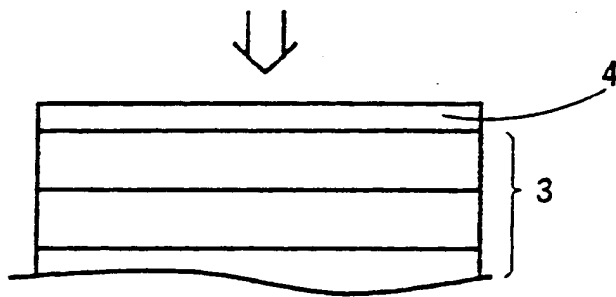


FIG. 2



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 94 30 5831

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
A	EP-A-0 470 757 (MITSUBISHI GAS CHEMICAL COMPANY)	1,2,4-7, 9-11, 13-16	H05K3/00 B23Q11/10
D	* the whole document * & JP-A-4 092 494 (...)		
A	EP-A-0 264 816 (LUBRA SHEET CORPORATION)		
D	& US-A-4 781 495 (HATCH ET AL.)		
D	& US-A-4 929 370 (HATCH ET AL.)		
			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			H05K B23Q
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 14 December 1994	Examiner Mes, L
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			

EPO FORM 1503 (03.82) (P/M/C01)

